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(54) **PROCESS FOR THE MANUFACTURING OF SURFACE ELEMENTS**

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This patent is subject to a terminal disclaimer.

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(58) **Field of Classification Search**

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See application file for complete search history.

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(57) **ABSTRACT**

A process for the manufacturing of surface elements is provided herein. The surface elements can include a decorative upper layer and a supporting core. A supporting core with a desired format can be manufactured by press molding and provided with an upper side and a lower side. The upper side of the supporting core can be provided with a structure by a momentary pressing operation using a surface structured matrix. A ground coating can be provided on the structured upper side of the supporting core. A digitally printed decor comprising inks of at least four colors can be applied directly on top of the ground coating by an ink-jet type printer. The structure of the supporting core can enhance the realism of the decor, wherein the decor can be selected from the group consisting of woods and minerals.

18 Claims, 3 Drawing Sheets

